



ITEM	QTY	SPARE	TOTAL	PART NUMBER	DESCRIPTION	MATERIALS
1	2			D040297	LIFTING SECTION (LONG); (LOWER STRUCTURE TOOLING)	AL ALLOY; 5083
2	2			D040298	CAPTURE AND UNION PLATE; (LOWER STRUCTURE TOOLING)	AL ALLOY; 5083
3	1			D040299	TOP PLATE LARGE; (LOWER STRUCTURE TOOLING)	AL ALLOY; 5083 OR SIMILAR
4	16			D040301	LONG BARREL NUT; (LOWER STRUCTURE TOOLING)	ST STEEL; 300 SERIES
5	4			D040303	LEG; (LOWER STRUCTURE TOOLING)	AL ALLOY; 5083 OR SIMILAR
6	1			D070010	TOP PLATE LARGE; (LOWER STRUCTURE TOOLING)	AL ALLOY; 5083 OR SIMILAR
7	4				1/4" 20 UNC X 1" CAP HEAD	
8	16				1/4" 20 UNC X 2" CAP HEAD SILVER PLATED	

**NOTES: (UNLESS OTHERWISE SPECIFIED)**

- REMOVE ALL SHARP EDGES. R.02 MIN.
- DO NOT SCALE FROM DRAWING.
- ALL MACHINING FLUIDS SHALL BE WATER SOLUBLE AND FREE OF SODIUM, CHLORINE AND SILICONE. SUCH AS CINCINNATI MILACRON'S CIMTECH 410 (STAINLESS STEEL).
- SCORE, ENGRAVE OR STAMP DRAWING PART NUMBER ON NOTED SURFACE OF PART AND A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST PART AND PROCEED CONSECUTIVELY. USE 07" HIGH CHARACTERS. EXAMPLE: D040298-001 - A VIBRATOR TOOL MAY BE USED.

**DIMENSIONS ARE IN MM (INCHES) TOLERANCES:**  
 X .XX ±.N/A IT  
 ANGLE ±.N/A °

**MATERIAL:** AS DRW  
**FINISH:** AS DRW  
 √(um) (µin) Ra: -

**DATE:** 22/FEB/07  
**NAME:** I WILMOT  
**DATE:** 21/FEB/07  
**CHECKED:** J'OD  
**APPROVED:** IW

**SCALE:** 3:16 PROJECTION:

**CALIFORNIA INSTITUTE OF TECHNOLOGY**  
 MASSACHUSETTS INSTITUTE OF TECHNOLOGY  
 RUTHERFORD APPLTON LABORATORIES

**SYSTEM:** aLIGO  
**SUB-SYSTEM:** SUS  
**NEXT ASSY:** QUAD TOOLING  
**PART NAME:** TEST CHAIN TOOLING  
**(LOWER STRUCTURE TOOLING)**

**DRG. NO.:** D060305  
**SHEET:** 1 OF 1